

Work Order ID 111266

Thursday, January 09, 2014 2:31:29 PM

111266

Page 1

Item ID: PB67-43001-67

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 90° Blade Support Assembly

Stop ***NS2***

Start Date: 1/9/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: mf

Date: 14-01-09 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-67	Rev C								
150	Weld per dwg A/R Aluminum rod Batch: <u>12507</u>	0.00	<u>CPC 14-1-16</u> <u>4</u>						
150	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- Install nut plates as per dwg								
	2- Weld assembly as per dwg B67-43001								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.00							
Quality Control									<u>④</u> <u>14-01-17</u> <u>DAS</u> <u>9</u> <u>9-89</u>
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							
Quality Control									<u>④</u> <u>14-01-17</u> <u>DAS</u> <u>9</u> <u>9-89</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 111266***111266***

Page 2

Thursday, January 09, 2014 2:31:29 PM

Item ID: PB67-43001-67

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: 90° Blade Support Assembly

Stop ***NS2***

Start Date: 1/9/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Identify as per dwg & Stock Location: SEP 0.00***200***

WAC03

Packaging

Memo

0.00

Packaging

4X 14-1-21

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.00

Quality Control

MLJ 14-01-22

① 14-01-21

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 09, 2014 2:31:26 PM

Page 1

Work Order ID: 111266
 Parent Item: PB67-43001-67
 Parent Item Name: 90° Blade Support Assembly

Start Date: 1/9/2014 Required Date: 1/24/2014
 Start Qty: 4.00 Required Qty: 4.00

Comments: IPP Rev:A 08-06-19 new issue DD verified by:ec
 IPP Rev:B 08-09-23 remove alodine and QC3 DD verified EC IPP rev B 10.09.30 per rev C
 dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L3 Nut Plate	MS21075L3N	Purchased	No				Each	103.0000		24		Cpl 14.1.16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		103							
					125646	103							
PB67-43001-147 Support Plate		Manufactured	No				Each	4.0000		4		Cpl 14.1.16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		4							
					52639	4							
PB67-43001-149 Side Plate		Manufactured	No				Each	20.0000		8		Cpl 14.1.16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz2		20							
					99999	20							
MS20426AD3-4 RIVET		Purchased	No			100	Each	11,459.000	12	48		Cpl 14.1.16	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST334		4000							
					m127432	4000							
				ST509		7459							
					125578	7459							

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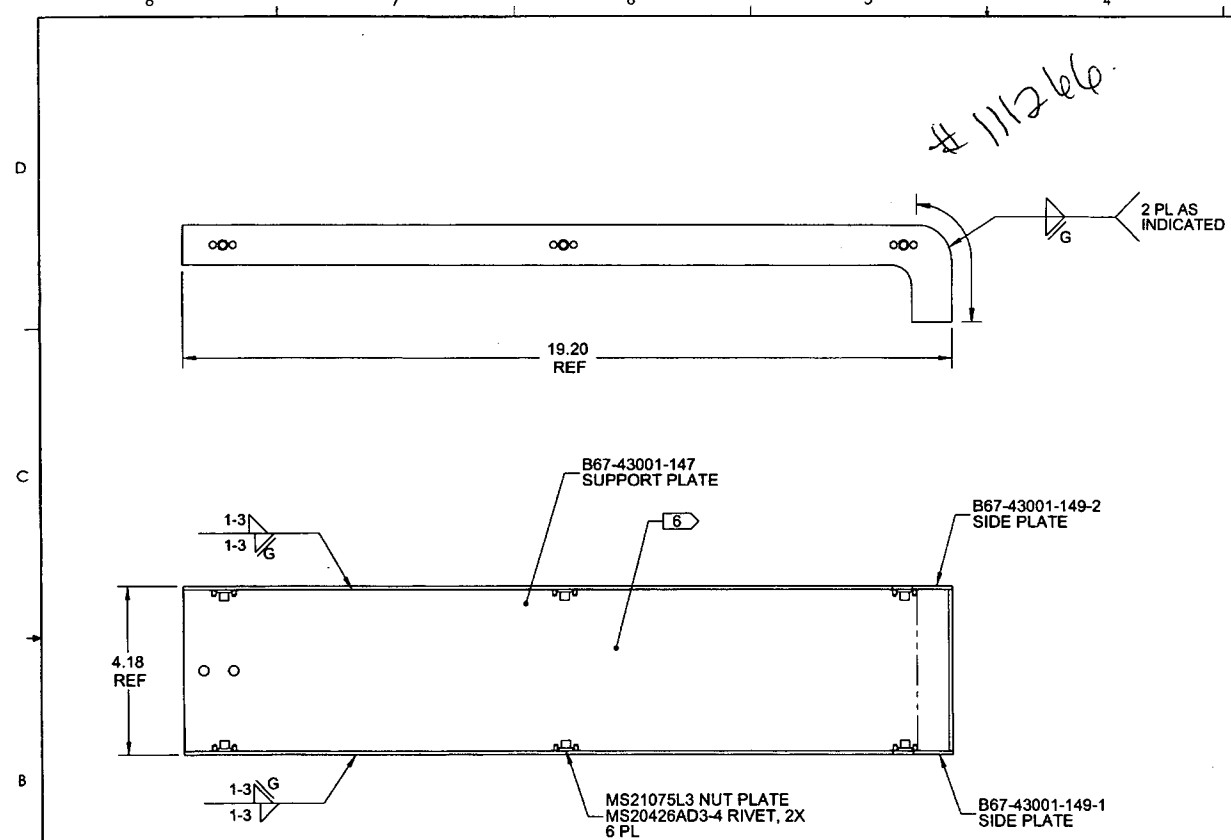
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111266

ITEM	QTY -67	P/N	DESCRIPTION
1	X	B67-43001-67	90-DEGREE SUPPORT PLATE ASSY
2	1	B67-43001-147	SUPPORT PLATE
3	1	B67-43001-149-1	SIDE PLATE
4	1	B67-43001-149-2	SIDE PLATE
5	12	MS20426AD3-4	RIVET
6	6	MS21075L3	NUT PLATE



B67-43001-67 90-DEGREE BLADE SUPPORT ASSY

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-67" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) WELDING: PER QSI 004

RELEASED
2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING (AW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 9 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.04.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-67**

TITLE **90-DEGREE BLADE SUPPORT ASSY**

SCALE **NTS**

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